Work Order ID 79029
January-18-12 3:16:00 PM

79029

Item ID: D3914-041
Revision ID:
Item Name: Long Basket Lid Assembly (350)

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 18/01/2012 **Start Qty:** 1.00 *1*
Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** M.C.J **Date:** 12/01/18 **Tooling:** ______ **Date:** ______
QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Run **Start** *NR1*
Stop *NR2*

Draw Nbr	Revision Nbr
D3914	B

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Large Fab / Large Fab	Weld per dwg A/R S.S. rod Batch: 117884 Large Fab	0.00				1	Ø		
	Memo	0.00	12·02·08						
110 *110* QC / Quality Control	QC9- Inspect visual per QS1004- Fusion Welds	0.00	12.02.13			1	Ø		
	Memo	0.00							

Memo (100):
1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
make sure to place mesh correctly on lid, check with label plate before tacking mesh

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79029 *79029*

January-18-12 3:16:00 PM

Item ID: D3914-041 **Accept** *N900040100* **Setup** **Start** *NS1* **Stop** *NS2*

Revision ID:

Item Name: Long Basket Lid Assembly (350)

Start Date: 18/01/2012 **Start Qty:** 1.00 *1*

Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1*

Cust Item ID:

Customer:

Reference:

Run **Start** *NR1* **Stop** *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing **Memo**	0.00 0.00 S 12/02/13							
130 *130* Powdercoat Powder Coating M115128	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 **Memo** *** mask sides of hinge prior to powdercoat*** Start Time: 11:30 Oven Temperature: 320°F Finish Time: 12:00	0.00 0.00				1	XGM		12/02/23
140 *140* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 120125 **Memo** 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00 0.00				1	BR		12-2-23.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 79029

January-18-12 3:16:00 PM

79029

Item ID: D3914-041

Revision ID:

Item Name: Long Basket Lid Assembly (350)

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 18/01/2012 **Start Qty:** 1.00 *1*

Required Date: 01/02/2012 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________

Run **Start** *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish	0.00				1	ɸ		RL 12/02/23
	Memo	0.00							
160 *160* Packaging Packaging	Identify as per dwg & Stock Location: D4030-0411	0.00	79025			1			BL 12-2-23
	Memo	0.00							
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							MCJ 12/02/24
	Memo	0.00							

R 12-02-24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Picklist Print

January-18-12 3:16:04 PM

Work Order ID: 79029 *79029*

Parent Item: D3914-041 *D3914-041*

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 18/01/2012 **Required Date:** 01/02/2012

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 *D2581* Mounting Bracket		Manufactured	No			100	Each	73.0000	2 **	2		Cpl 12.02.08	
D3914-1 *D3914-1* Rib		Manufactured	No			100	Each	1.0000	2 **	2		Cpl 12.02.08	
D3914-7 *D3914-7* Rib		Manufactured	No			100	Each	6.0000	2 **	2		Cpl 12.02.08	
D4016-3 *D4016-3* Hinge Half, Lid		Manufactured	No			100	Each	12.0000	3 **	3		Cpl 12.02.07	

D2581 locations

Location	Loc Qty	Loc Code	
WA005	73		
69739	1		
70766	2		
77045 (circled)	41		(2)
77523	29		

D3914-1 locations

Location	Loc Qty	Loc Code	
WA	1		B77814 → (2)
77144	1		

D3914-7 locations

Location	Loc Qty	Loc Code	
WA006	6		
78695 (circled)	6		(2)

D4016-3 locations

Location	Loc Qty	Loc Code	
WA005	12		
74909 (circled)	12		(3)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ PAR #: ______ Fault Category: ______________ NCR: Yes No DQA: _____ Date: ________

Resolution: ______________ Disposition: ______________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Picklist Print

January-18-12 3:16:04 PM

Work Order ID: 79029 *79029*

Parent Item: D3914-041 *D3914-041*

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 18/01/2012 **Required Date:** 01/02/2012

Start Qty: 1.00 **Required Qty:** 1.00

✓ D4018-5 *D4018-5* Rib | Manufactured | No | 100 | Each | 1.0000 | 9 | 9 | ** | Cpl 12.02.08

Location		Loc Qty	Loc Code
WA		1	
	77813	1	

B78404 → 9

✓ D4020-5 *D4020-5* Mesh (350 Basket Long, Lid) | Manufactured | No | 100 | Each | 1.0000 | 1 | 1 | ** | Cpl 12.02.08

Location		Loc Qty	Loc Code
WA		1	
	78040	1	

B78698 → 1

✓ D4021-3 *D4021-3* Data Plate | Manufactured | No | 100 | Each | 7.0000 | 1 | 1 | ** | Cpl 12.02.08

Location		Loc Qty	Loc Code
WA005		7	
	75460	7	1

✓ D4035-041 *D4035-041* Lid Rib Assembly, Fwd (350 Basket) | Manufactured | No | 100 | Each | 1.0000 | 1 | 1 | ** | Cpl 12.02.08

Location		Loc Qty	Loc Code
WA006		1	
	76332	1	

B74642 → 0

✓ D4035-043 *D4035-043* Lid Rib Assembly, Aft (350 Basket) | Manufactured | No | 100 | Each | 5.0000 | 1 | 1 | ** | Cpl 12.02.08

Location		Loc Qty	Loc Code
WA006		5	
	76545	5	1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Picklist Print

January-18-12 3:16:04 PM

Work Order ID: 79029 *79029*

Parent Item: D3914-041 *D3914-041*

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 18/01/2012 **Required Date:** 01/02/2012

Start Qty: 1.00 **Required Qty:** 1.00

D2728-3 *D2728-3* Dart Logo label	Manufactured	No	140	Each	0.0000	1	1	
		15050.				**	1	BK 12-2-23.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

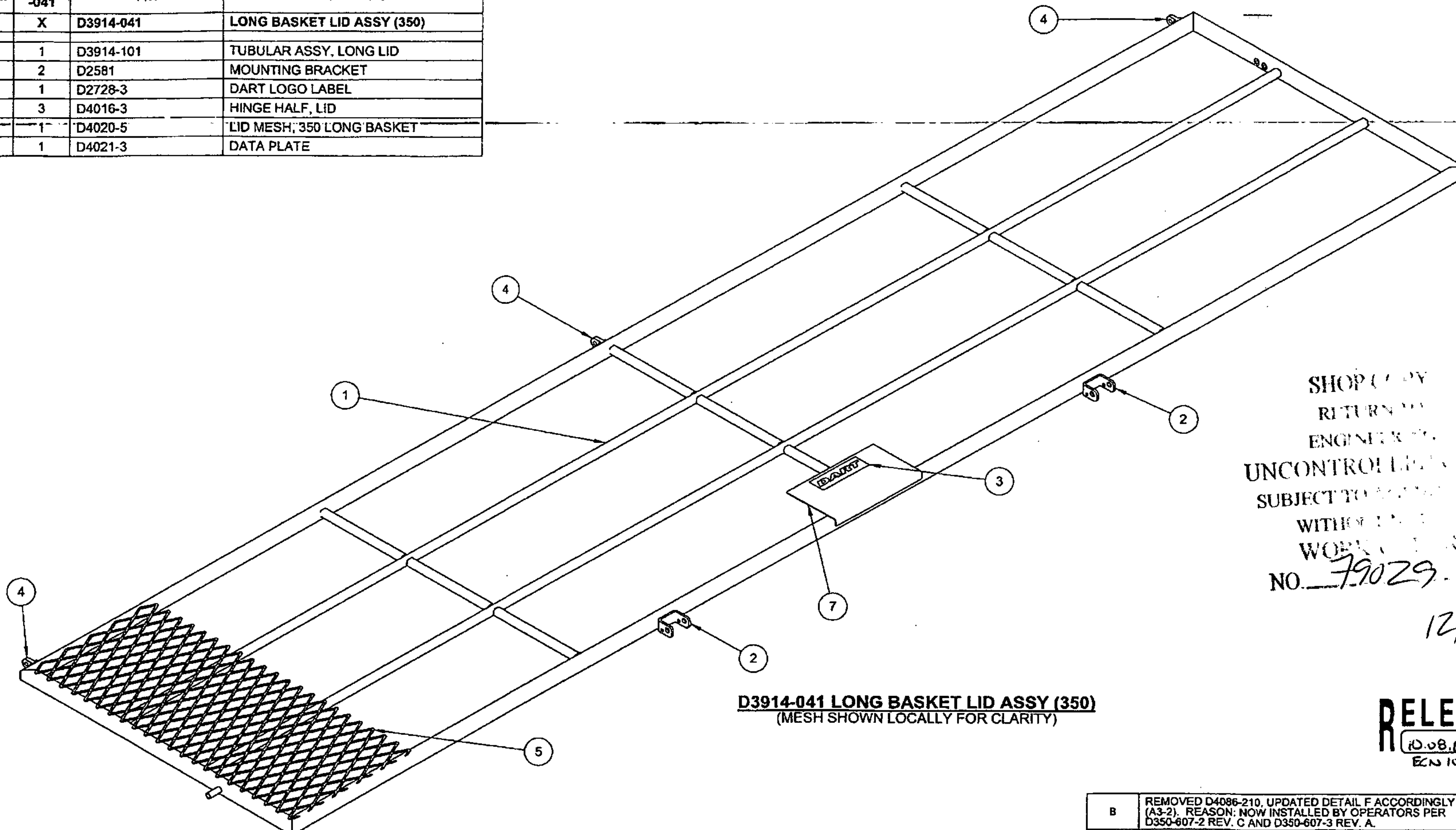
Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP C...
RETURN ...
ENGINE...
UNCONTROLL...
SUBJECT TO ...
WITHO...
WOR...
NO. 79029. M.C.J
12/01/18

RELEASED 10.08.17 ECN 10-596

REV.	DESCRIPTION	BY	DATE
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16

DESIGN	AJS
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.08.05

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3914 — REV. B — SHEET 1 OF 4

TITLE: LONG BASKET LID ASSY (350) — SCALE: NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

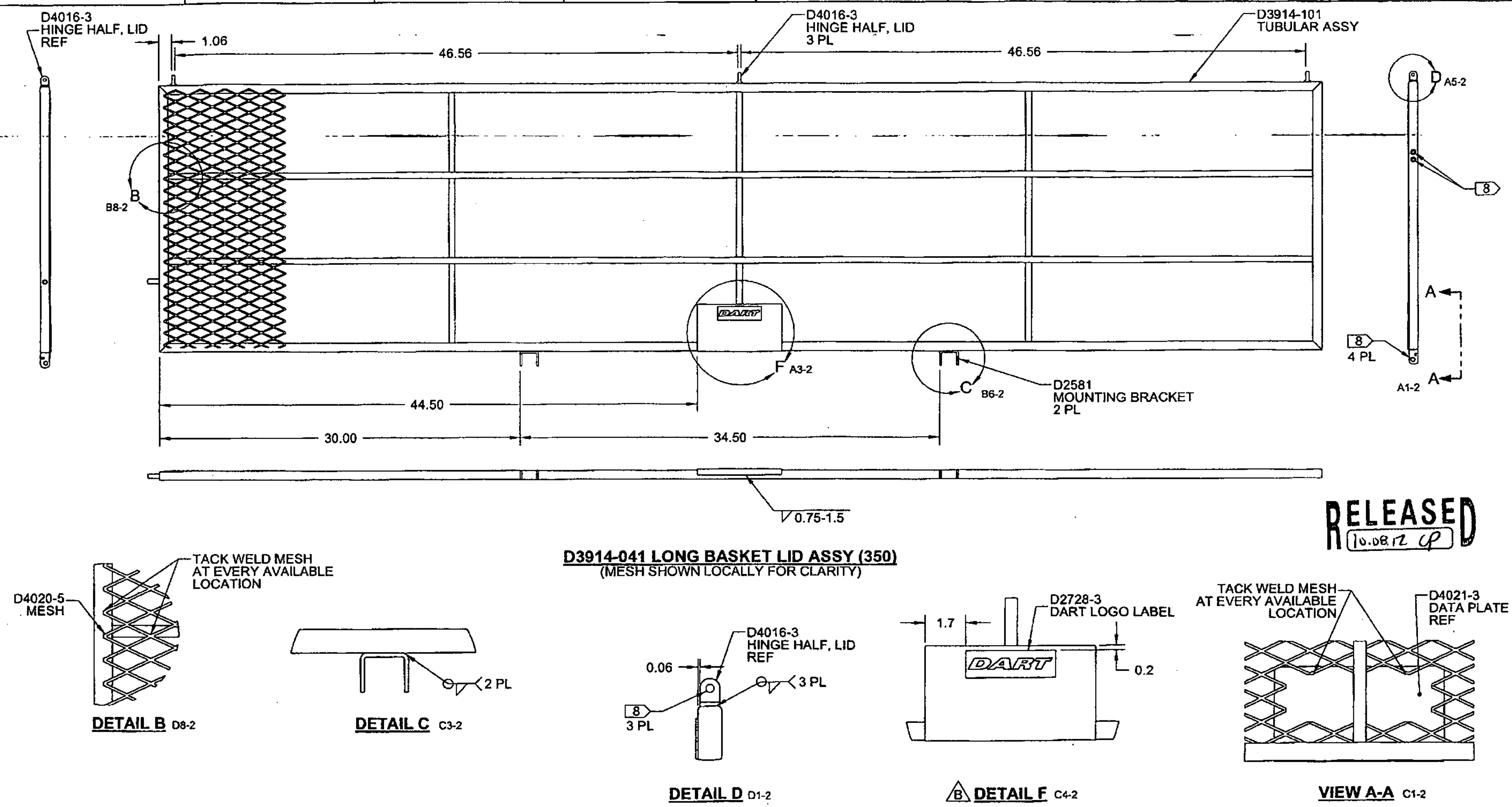
Resolution: ____________________ Disposition: __________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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79029



NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 22.35 lbs APPROX
8) MASK HOLES PRIOR TO FINISHING
9) WELD PER DART QSI 004

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3914 — REV. B — SHEET 2 OF 4
CHECKED		
MFG. APPR.		TITLE: LONG BASKET LID ASSY (350) — SCALE: NTS
APPROVED		
DE APPR.		
DATE	10.08.05	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

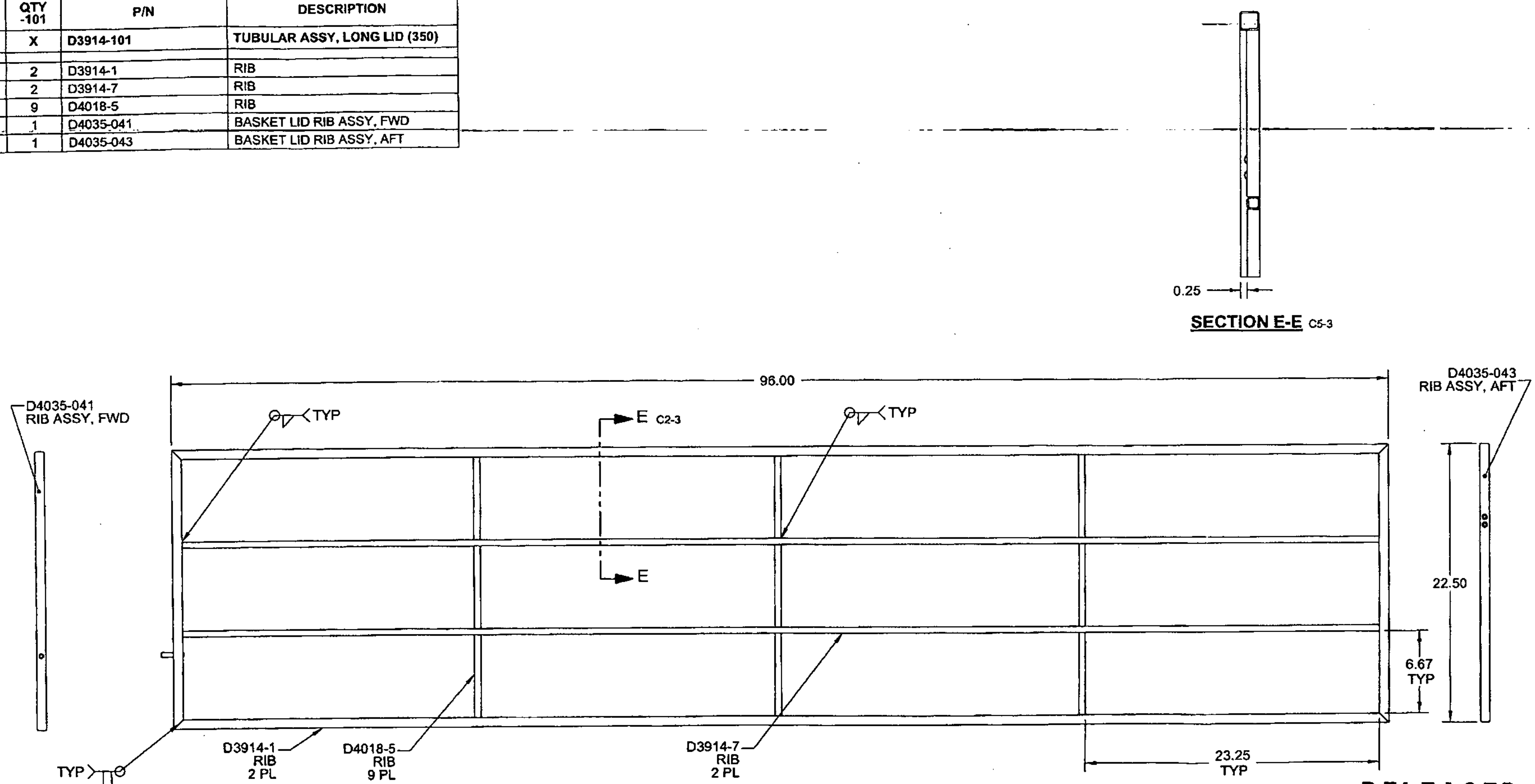
Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79029

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



RELEASED 10.08.12

8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 14.10 lbs
8) TOLERANCE FOR XX.XX DIMENSIONS ±0.06 FOR D4018-101
9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D3914 REV. B SHEET 3 OF 4
CHECKED		
MFG. APPR.		
APPROVED		TITLE LONG BASKET LID ASSY (350) SCALE NTS
DE APPR.		
DATE	10.08.05	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

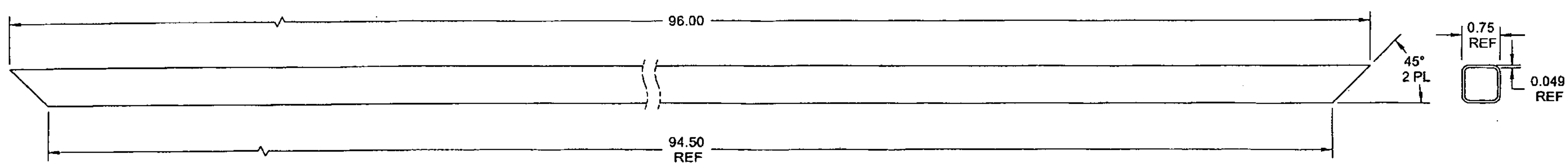
Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

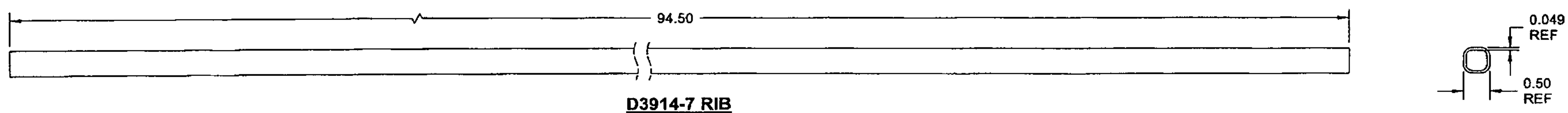
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79029



D3914-1 RIB



D3914-7 RIB

NOTES:
1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED 10.08.12

DESIGN	AS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED	SC	DRAWING NO. D3914 — REV. B — SHEET 4 OF 4
MFG. APPR.		
APPROVED		TITLE: LONG BASKET LID ASSY (350) — SCALE: NTS
DE APPR.		
DATE	10.08.05	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ________ Fault Category: ____________ NCR: Yes No DQA: ______ Date: __________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: __________ Date: __________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

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